

Date: Monday, 22/12/2008 3:06:07 PM
User: Melanie Fauteux





Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 44251	
Estimate Number : 12041	
P.O. Number :	Part Number : D33553
This Issue : 22/12/2008 S.O. No. :	Drawing Number : D3355 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 34645	Material :
Written By :	Due Date : 20/01/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JD 08.12.23</u>	
Comment : est rev A 06.01.19 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1018TR1500W109	1018-1025 Steel tubing 1.50 x .109w
 		
Comment: Qty.: 2.5463 f(s)/Unit Total : 15.2775 f(s) AISI 1018-1025 mild steel seamless round tubing 1.500" od X 0.109" wall batch: <u>1105645</u> <u>09/01/10</u> <u>6 pcs</u> pto		
2.0	BAND SAW	BAND SAW
 		
Comment: BAND SAW Cut blank 29.00" long <u>09/01/10</u> <u>6 pcs</u> pto		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
 		
Comment: CONVENTIONAL MILLING MACHINE 1- Drill & c'sink as per dwg D3355 2-Deburr as per dwg D3355 <u>09/01/10</u> <u>6 pcs</u> pto		
4.0	QC5	INSPECT WORK TO CURRENT STEP
 		
Comment: INSPECT WORK TO CURRENT STEP <u>09/01/10</u> <u>6</u>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST 493</u> <u>09/01/14</u> <u>6</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3355-3 PAR #: NA Fault Category: Prod / ~~Material~~ ^{PhB med & small} NCR: Yes No DQA: D Date: 09/01/16
D3355-045 - D3355-041 - D206-731-011
 Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 09/01/16

NCR: <u>44251</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/10	3.0	2 pieces scrapped. 1st piece hole not in tolerance 6.000 ± .010 → 5.973 actual. 2nd piece chamfer too large on two holes. Moved in vice.	<u>DB</u> 09/01/12	Scrap and Destroy and replace Qty <u>42</u> M <u>M105645</u>	<u>DB</u> 09/01/10	<u>DB</u> 09/01/12	<u>DB</u> 09-01-10	<u>DB</u>
		R.C. vice was not tight enough.						

NOTE: Date & initial all entries

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Drawing Name: HANDLE WELDMENT

Job Number: 44251

Part Number: D33553

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/15 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

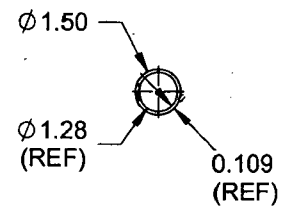
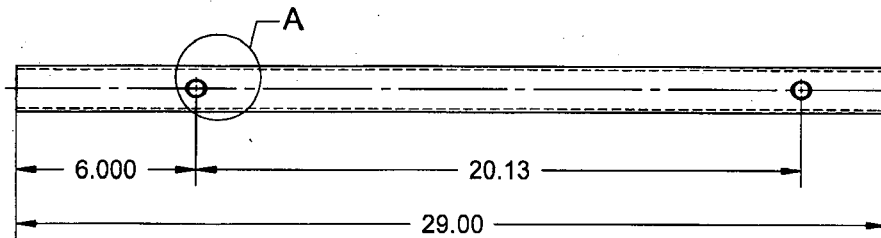
DART

DESIGN RF	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3355	REV. B SHEET 5 OF 6
DATE 06.05.31	TITLE HANDLE WELDMENT	SCALE 1:6	

CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)

DETAIL A
SCALE 1 : 2



7345

D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

SHOP COPY
RETURN TO
ENGINEERING

CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44251

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